

Date: Thursday, 26/02/2009 8:32:59 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AVIONICS RISER CONSOLE
Job Number	: 46080		
Estimate Number	: 10259		
P.O. Number	:	Part Number	: D212722011
This Issue	: 26/02/2009 S.O. No. :	Drawing Number	: D3363 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 37738	Material	:
Written By	:	Due Date	: 05/03/2009 Qty: 4 Um: Each
Checked & Approved By	: <u>mf 09-02-26</u>		
Comment	: Est Rev:B 05.04.11 Now made at Dart KJ/JLM Est Rev:C 07-06-09 Holes now Transfer drilled JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



Hf for 30 09/03/10



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D212-722-011 CHG002

2.0

M6063T5A0750W063

Angle6063T5 .750 X.750 X.063w



Comment: Qty.: 7.2450 f(s)/Unit Total : 28.9800 f(s)

Material: 6063-T52 Aluminum angle 3/4" x 3/4" x 0.063" wall(M6063T5A0.750W.063)

Batch: M111018

FF 09/03/04 (4)

3.0

M6063T5C75X75W125

6063 CHANNEL.750 X.750 X.125w



Comment: Qty.: 0.8290 f(s)/Unit Total : 3.3160 f(s)

Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall(M6063T5C.75x.75W.125)]

Batch: M17080

FF 09/03/04 (4)

4.0

D33631

Console



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3363-1 Console (Bent) 44254

FF 09/03/04 (4)

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut (2) D3360-1, (2) D3360-3 & (2) D3360-5 to length as per Dwg D3360Material: 6063-T52 Aluminum
angle 3/4" x 3/4" x 0.063" wall

FF 09/03/04 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 26/02/2009 8:32:59 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AVIONICS RISER CONSOLE

Job Number: 46080

Part Number: D212722011

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut (1) D3361-1 to length as per Dwg D3361 Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall

3-Deburr D3360-1/-3/-5 & D3361-1

4-Transfer drill and C'Sink D3360-1/-3/-5 & D3361-1 from D3363-1 as per D3363. Do not rivet together

5-Deburr all parts

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(4)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BF 09-03-4

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-04

(4)

8.0

PR351

DZUS FASTENER RAIL



Comment: Qty.: 0.3333 f(s)/Unit Total : 1.3332 f(s)

Material: Dzus Fastener Rail

(PR35-1 or PR3-1/2-1)

Batch: M107913

FF 09-03-10

(4)

9.0

MS20426AD45

Rivet



Comment: Qty.: 44.0000 Each(s)/Unit Total : 176.0000 Each(s)

Pick:

Qty Part Number

Description Batch

44 MS20426AD4-5

Rivet 4067

FF 09-03-10

(4)

10.0

MS20426AD46

Rivet



Comment: Qty.: 9.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number

Description Batch

9 MS20426AD4-6

Rivet M105144

FF 09-03-10

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 26/02/2009 8:32:59 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AVIONICS RISER CONSOLE

Job Number: 46080

Part Number: D212722011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut (2) D3362-1 to length as per Dwg D3362 Material: Dzus Fastener Rail

Mount Dzus Rails to DT8957 (Radio) and transfer drill into console.*

2-Rivet D3360-1/-3/-5 & D3361-1 & D3362-1 as per Dwg D3363

Identify as D3363-041

FF 09-03-10

(4)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-03-10 (4)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

14.0

PFSC3538A

Dzus 1/4 turn fastener



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty-Part Number

Description Batch

8 PFSC35-38A

Dzus Fastener

1110836

1 d3363-041

Console Ass

46080

9/3/10

50

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

09-03-10 (4)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D212-722-011

Rev D 09/03/10

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/11

Job Completion



mk 09-03-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

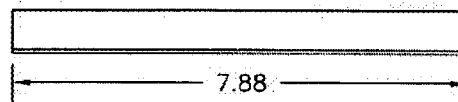
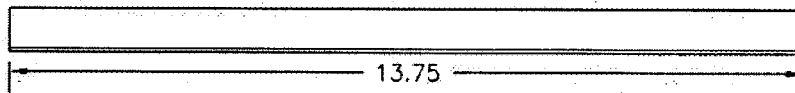
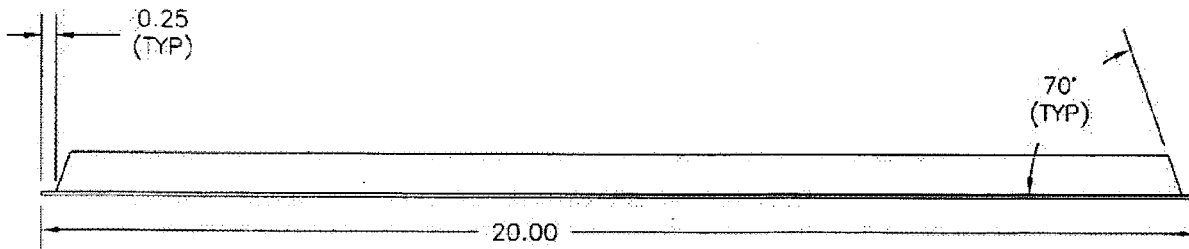
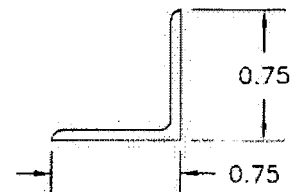
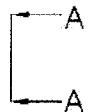
DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3360	REV. A SHEET 1 OF 1
DATE 04.11.29		TITLE ANGLE	SCALE 1:12
A	04.11.29	NEW ISSUE	

RELEASED

05-03-31 PH

46080

D3360-1
(SCALE 1:3)D3360-3
(SCALE 1:3)D3360-5
(SCALE 1:3)SECTION A-A
(SCALE 1:1)**D3360-1/-3/-5 ANGLE**

- 1) CUT LENGTH/SHAPE PER DIAGRAM
- 2) MATERIAL: 6063-T52 ALUMINUM
STOCK SIZE: 3/4" x 3/4" x 0.063" ANGLE EXTRUSION
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

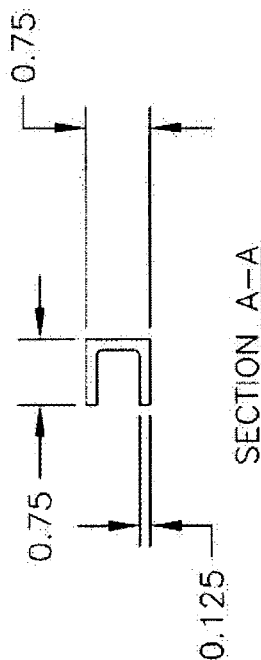
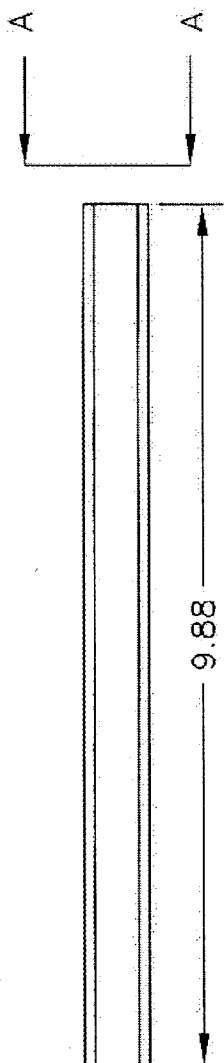
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN AH	DRAWN BY AH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED AH	APPROVED AH	DRAWING NO. D3361	REV. A SHEET 1 OF 1
DATE 04.11.29		TITLE CHANNEL	SCALE 1:2
A	04.11.29	NEW ISSUE	



RELEASED

05-03-11

46080

D3361-1 CHANNEL

- 1) CUT LENGTH/SHAPE PER DIAGRAM
- 2) MATERIAL: 6063-T52 ALUMINUM
STOCK SIZE: 3/4" x 3/4" x 0.125" CHANNEL EXTRUSION
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

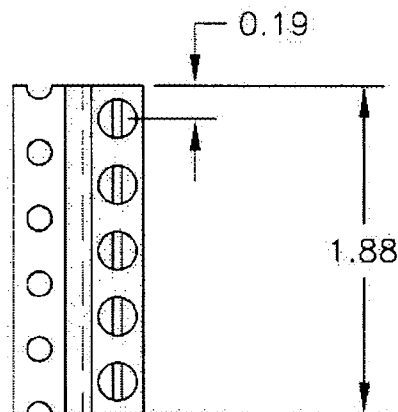
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CHECKED PH	APPROVED PH	DRAWING NO. D3362	REV. A SHEET 1 OF 1
DATE 04.11.29		TITLE RAIL	SCALE 1:1
A	04.11.29	NEW ISSUE	

RELEASED
05-03 31 PH



46080

D3362-1 RAIL

- 1) CUT LENGTH/SHAPE PER DIAGRAM
- 2) MAKE FROM DZUS RAIL P/N "PR 3-1/2-1" OR PR-35-1
- 3) TOLERANCES ARE PER DART QSI 018
- 4) ALL DIMENSIONS ARE IN INCHES

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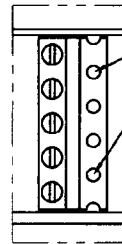
DESIGN	DRAWN BY	DART AEROSPACE LTD	
P41	P41	HAMKESBURT, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE		D3363	SHEET 1 OF 3
07.01.26		TITLE	SCALE
		CONSOLE ASSEMBLY	1:5

A	04.11.29	NEW ISSUE
B	05.03.28	INCREASE WIDTH BY 0.125
C	07.01.26	T'DRILL DZUS RAIL, WIDEN BASE CUTOUT

RELEASED

07.06.04

TRANSFER DRILL #30 FROM D3362-1 DZUS RAIL THROUGH D3363-1 CONSOLE (TYP 4 PLACES) C'SINK (#0.225 X 100') FROM TOP SIDE OF CONSOLE



DETAIL C
(SCALE 1:2)

C'SINK THIS SIDE (REF)

INSTALL D3361-1 & D3362-1 USING MS20426AD4-6 RIVETS (TYP 9 PLACES)

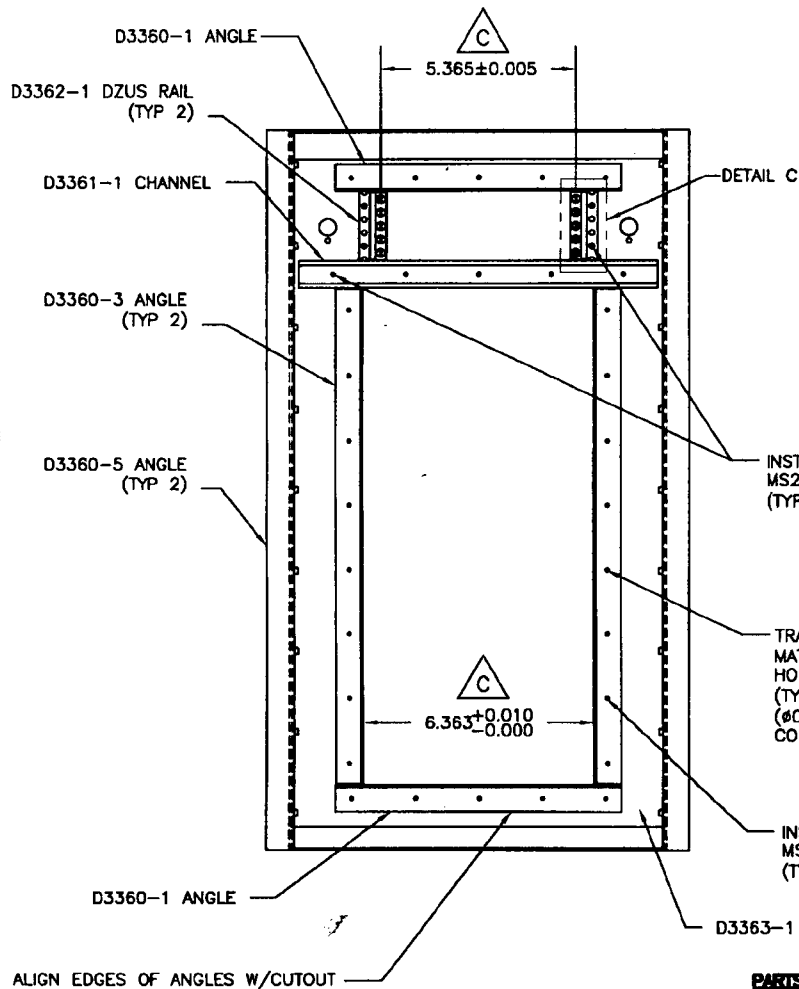
TRANSFER DRILL #30 FROM MATING PARTS THROUGH #40 HOLES IN D3363-1 CONSOLE (TYP 49 PLACES) C'SINK (#0.225 X 100') FROM CONSOLE TOP SIDE

INSTALL D3360-1/-3/-5 ANGLES USING MS20426AD4-5 RIVETS (TYP 44 PLACES)

D3363-1 CONSOLE

PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
X	D3363-041	CONSOLE ASSEMBLY
2	D3360-1	ANGLE
2	D3360-3	ANGLE
2	D3360-5	ANGLE
1	D3361-1	CHANNEL
2	D3362-1	RAIL
1	D3363-1	CONSOLE
44	MS20426AD4-5	RIVET
9	MS20426AD4-6	RIVET



VIEW A-A FROM UNDER CONSOLE ASSEMBLY

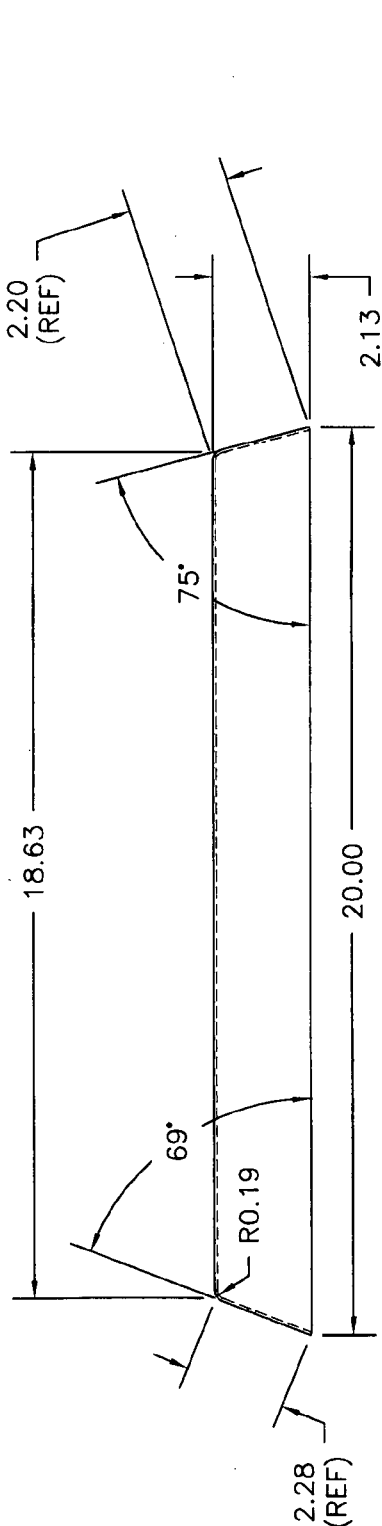
D3363-041 CONSOLE ASSEMBLY

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

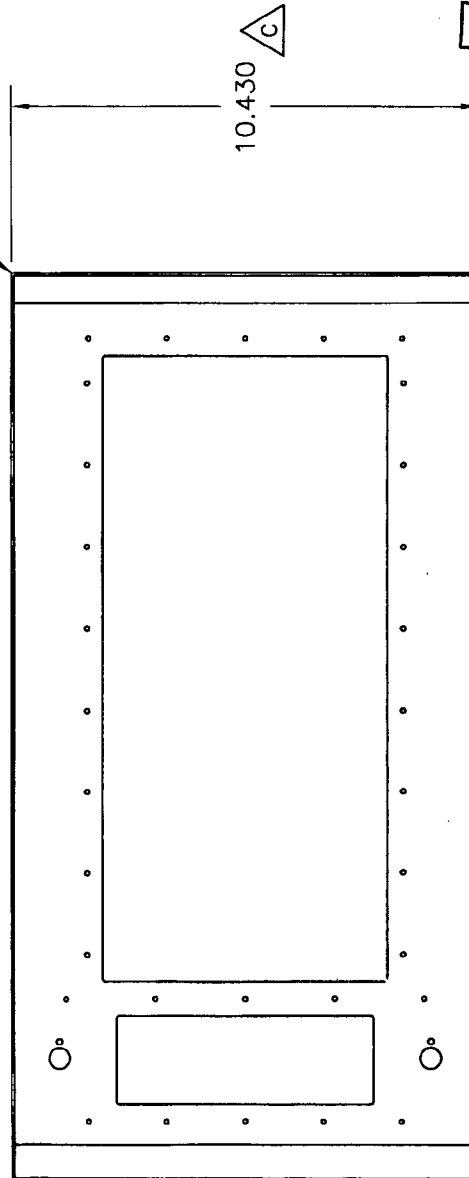
46080



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4



GRIND OUTSIDE
WELD FLUSH
(TYP 4 PLACES)



RELEASED

07.06.04 *[Signature]*

D3363-1 BEND DETAIL
(MAKE FROM D3363-1F FLAT PATTERN)

46080

D3363-1 CONSOLE

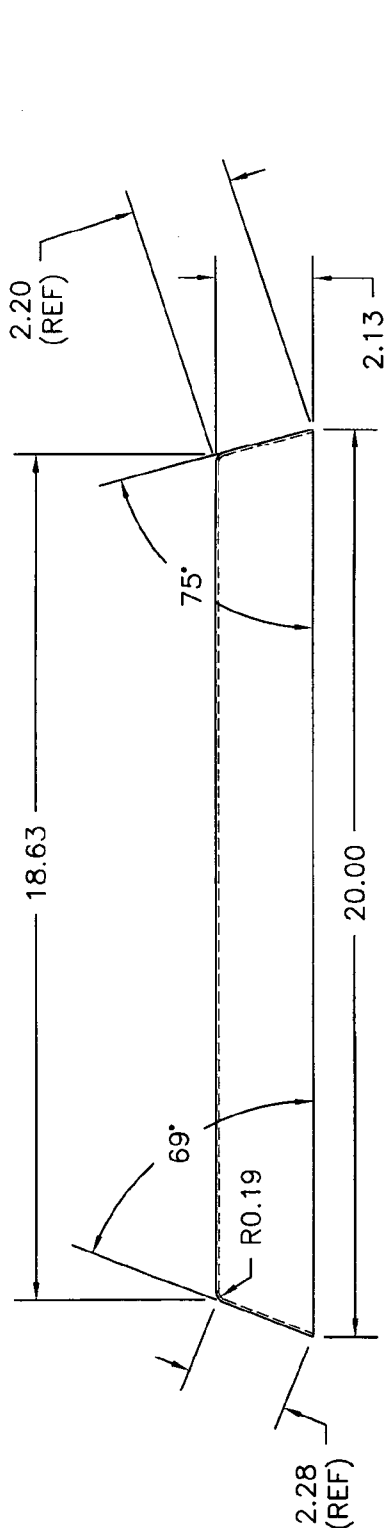
- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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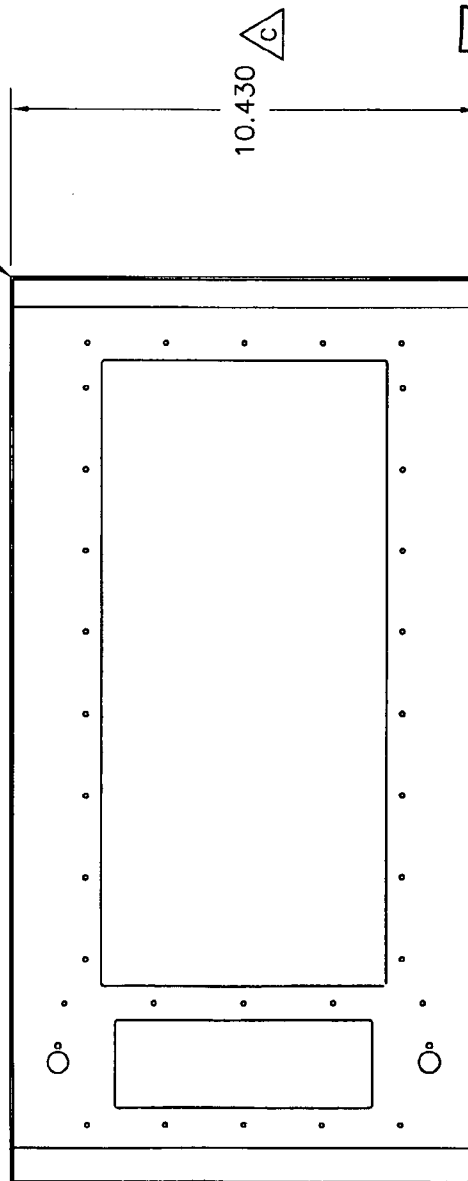
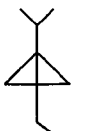
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4



GRIND OUTSIDE
WELD FLUSH
(TYP 4 PLACES)



RELEASED

07.06.04 *[Signature]*

D3363-1 BEND DETAIL

(MAKE FROM D3363-1F FLAT PATTERN)

D3363-1 CONSOLE

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

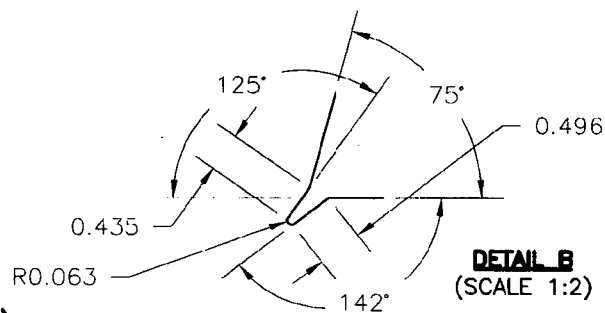
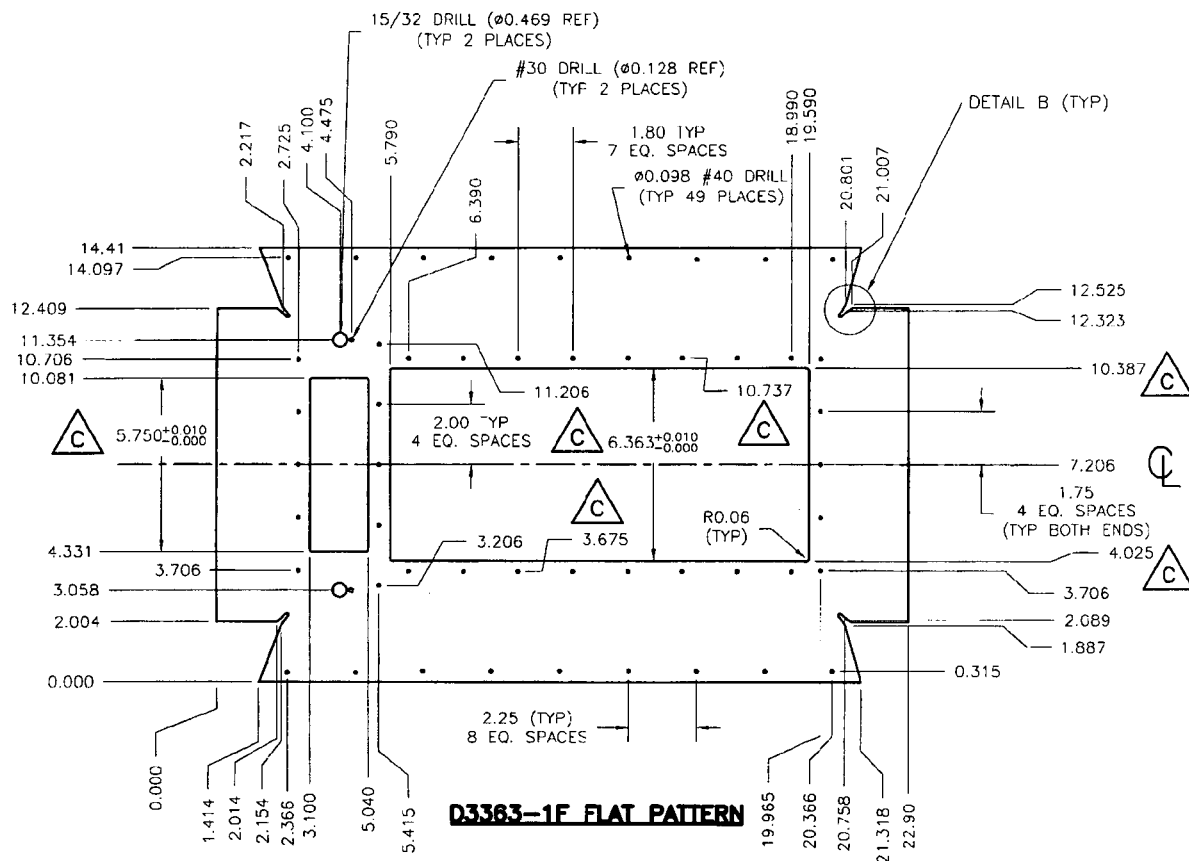
46080

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAMMERSBURT, ONTARIO, CANADA	
CHECKED 07.01.26	APPROVED 07.01.26	DRAWING NO. D3363	REV. C
DATE		TITLE CONSOLE ASSEMBLY	SHEET 3 OF 3
		SCALE 1:6	



D3363-1F CONSOLE (FLAT PATTERN)

- 1) MATERIAL: 6061-T6/T651 ALUMINUM 0.063 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE

RELEASED

07.06.04

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